



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2570**Job Sheet 200444****Part No:** D2570**Job Qty:** 160 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/11/19**Job Tracking No:****Due Date:** 10/16/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV B IPP E 02.08.29 Re-format; Removed finishing; Material change KJ IPP F 07.07.06 rev B dwg EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier Lead Time	
100	Hardinge - 1	160 pcs	10/16/19	10/16/19	0.50 6.40	Hardinge - 1	BM 19-10-11
110	QC 2	160 pcs	10/16/19	10/16/19	0.00 0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	19/10/11



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CANADA
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Container No: S221878**Part:** D2570**Job No:** 200444**Serial No/Batch:** S221878**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 10/11/19

120	QC 8	160 pcs	10/16/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
130	Packaging 3-1 - Stock - B4B	160 pcs	10/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

m 19/10/12

DAS
28
9-89

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	160 pcs	10/16/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	70
				QC 21 - SA - 53	OCT 16 2019 9-89
				Broussard	
Part Op 100 - (Hardinge) Machine as per folio FA258 Descriptions: 110 - (QC2- Inspect parts off machine FA/FAIB) 120 - (QC8- Inspect parts - second check) 130 - LOCATION : ST008 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R0.750	303 Round Bar 0.750	10.5600 ft (.066 ea)	100-Hardinge - 1	20 33 80	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M303R0.750	11	127	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.800inches ± 0.010	0.810 0.790	0.805	
2	Bushing	0.060inches ± 0.005	0.065 0.055	0.061	
3	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010	0.011	
4	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423	0.424	
5	Bushing	0.257inches + 0.006 - 0.001	0.263 0.256	0.260	
6	Bushing	0.750inches ± 0.010	0.760 0.740	0.745	
7	Bushing	0.030inches ± 0.010	0.040 0.020	0.033	
8	Bushing	20.000Degrees ± 0.000	20.000 20.000	20°	

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86" IN MACHINE TO START -

48"

48"

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐ ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ Other/Details: _____				Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐ Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐ ☐			
				Completed By							
				Lead hand / Supervisor							
				QC / QA Coordinator							



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D3849-041
Job Sheet 200454

Accounting Job SE19-646-017



Part No: D3849-041

Job Qty: 1 pcs

Part Name: Fwd Heavy-Duty Wearplate, Std Skid Compatible



Part Weight: 0 lbs

Status: New

Job Created: 9/11/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: DWG-REV-F IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.11 AS PER DWG REV.D DD
VERF:JLM IPP Rev:C 14.11.26 AS PER DWG REV.E DD VERF:JLM IPP REV:D 16.06.17 DWG REV.F DD
VERF:JLM

Ship Via:

POSITIVE RECALL

SEP 11 2019

RELEASED DATE 9-89

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Welded Assy-1	1 pcs	9/27/19		0.00	1.52	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	1 pcs	9/27/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 8		
130	QC 5	1 pcs	9/27/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140	Spray Paint - 2 - B4B	1 pcs	9/27/19	0.00 0.50	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
150	QC 5	1 pcs	9/27/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	1 pcs	9/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
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					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
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			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21
				QC 21 - SA - 70
				QC 21 - SA - 53

Part Op 110 - (Weld per dwg A/R S.S. rod Batch: _____)

Descriptions: 120 - (QC9- Inspect visual per QSI004- Fusion Welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Spray Paint / NDT Room) APPLY ROCKGUARD AS PER DWRG

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____) LOCATION : FG002

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3849-1	Plate	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	
D3901-041	Wearbar Weldment	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3849-1	1	9	0
	D3901-041	1	6	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

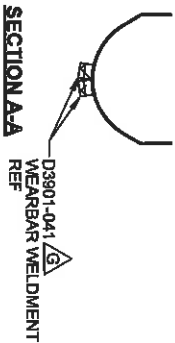
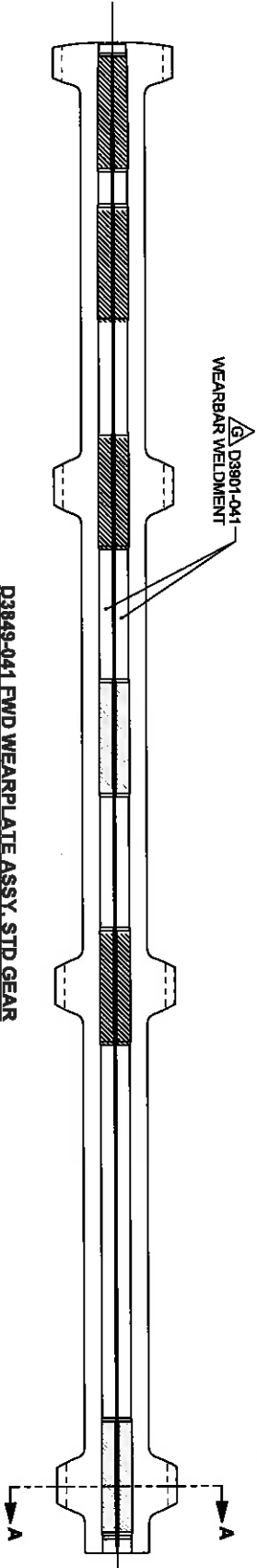
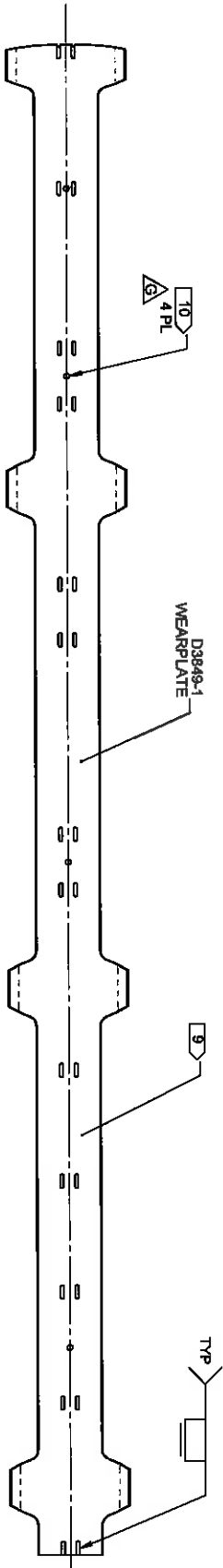
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
		Completed By _____			
		Lead hand / Supervisor _____			
		QC / QA Coordinator _____			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐

QTY	P/N	DESCRIPTION
441	D3849-041	FWD WEARPLATE ASSY, STD GEAR
X	D3849-041	WEARPLATE
1	D3849-1	WEARBAR WELDMENT
2	D3801-041	WEARBAR WELDMENT



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER OSI 044 6.1
 - 7) WEIGHT: 7.44 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART OSI 005 4.9.
 - 9) TRANSFER DRILL Ø0.188 HOLES FROM D3849-1 WEARPLATE TO D3801-041 WEARBAR, AFTER APPLYING TEXTURED COATING.

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	ZF	HILLBORO, OR
CHECKED	SAD	REV. G3
MFG. APPR.	DD	D3849
APPROVED		WEARPLATE ASSY
DATE	19.06.11	SCALE
		NTS

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